

Date Thursday, 16/08/2007 12:01:09 PM
User Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STA 84 BRACKET
Job Number : 34032-2
Estimate Number : 11035
P.C. Number : N/A Part Number : D28032
This Issue : 16/08/2007 S.O. No. : N/A Drawing Number : D2803 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : MACHINED PARTS Drawing Revision : B
Previous Run : 33599 Material : N/A
Written By : Due Date : 05/09/2007 Qty: 30 Um: Each
Checked & Approved By :
Comment : Est. A. 00.11.06 New Issue EC
Est Rev:B, Blanks now cut on Waterjet 06-06-14' JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X10000 6061-T6 Bar .50" x 10.0"



Comment: Qty.: 2.0125 f(s)/Unit Total: 60.3761 f(s)

6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch: M105145X21B07-08-20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Template DT8533

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA102

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2803-2 PAR #: NA Fault Category: Prod / machined ^{PAR} NCR: (Yes) No DQA: D Date: 01/21/07
 QA: N/C Closed: _____ Date: _____

NCR: <u>34032</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07Jul28	# 30	One part has the Depth (in section A-A) at 0.240 - instead of 0.250 ^{to spec 07.11.28} _{0.005" pl}	<u>JP</u> _{07.11.28} ₀₅₁₀₄₂	Accurate Dimension This one time only	<u>J.L.</u>	<u>JP</u> _{07.11.28} ₀₅₁₀₄₂	<u>JP</u> _{07.11.28} ₀₅₁₀₄₂	<u>JP</u> _{07.11.28} ₀₅₁₀₄₂
07Jul28	# 30	two parts have a flange thickness of 0.105" instead of 0.125"	<u>JP</u> _{07.11.28} ₀₅₁₀₄₂	Scrap and Destroy. Replace Both.	<u>J.L.</u> _{07.11.28}	<u>JP</u> _{07.11.28}	<u>JP</u> _{07.11.28}	<u>JP</u> _{07.11.28}

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 12:01:09 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 34032

Part Number: D28032

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

ML/J.L. 07/12/04 (28)

7.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

07/12/05 (28)

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

FL 07/12/05 (28)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST152

07/12/05 (28)

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

07/12/07 (28)

Job Completion



W 07/12/07

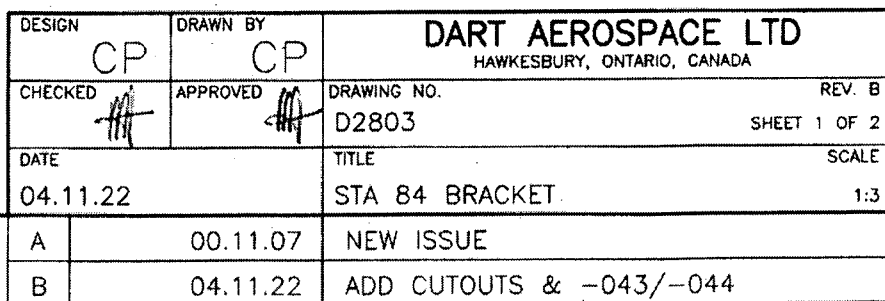
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

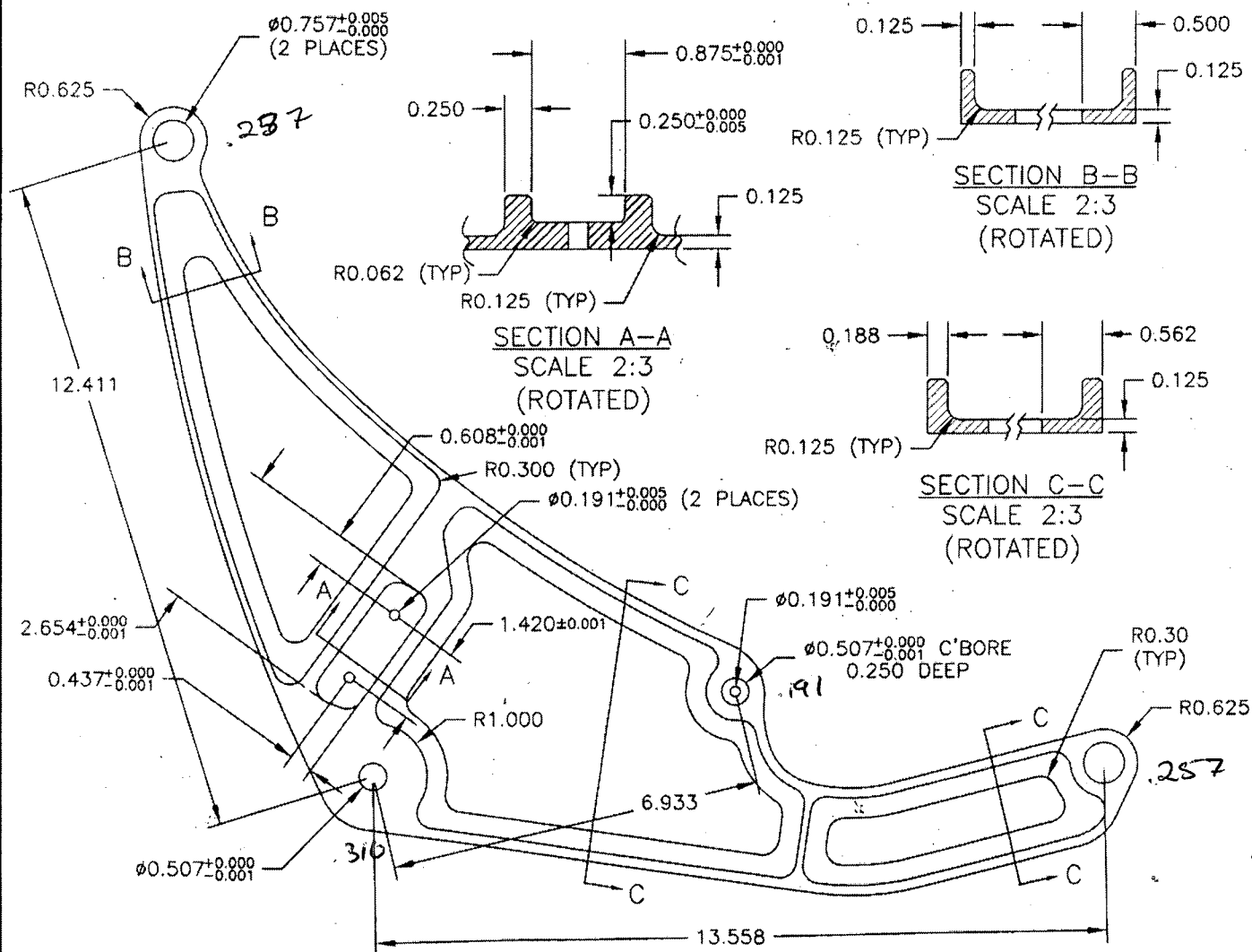
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



05.03.11



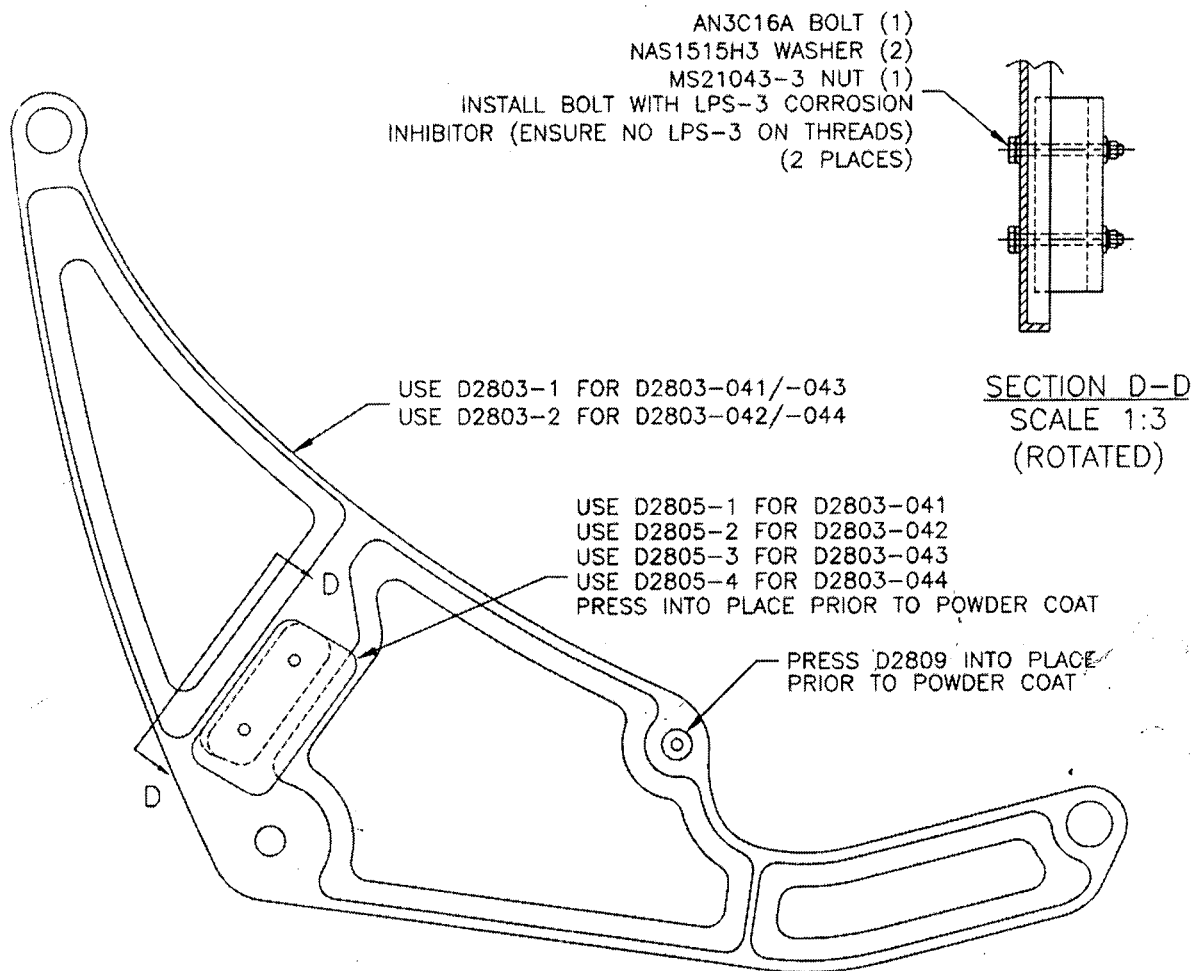
W/O 34032

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3



RELEASED

05.03.11

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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DART AEROSPACE LTD		Work Order: 34032
Description: Bracket		Part Number: D2803-2
Inspection Dwg: D2803	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	Ø0.7582	—			
1.420	+/-0.001	1.420	—			
Ø0.191	+0.005/-0.000	Ø0.192	—			
Ø0.507	+0.000/-0.001	Ø0.5064	—			
Ø0.507 x 0.250	+0.000/-0.001	Ø0.5065 x 0.250	—			
12.411	+/-0.010	12.411	—			
6.933	+/-0.010	6.930	—			
0.250	+/-0.010	0.257	—			
0.875	+0.000/-0.005	0.8745	—			
0.250	+0.000/-0.005	0.248	—			
0.125	+/-0.010	0.125	—			
0.125	+/-0.010	0.124	—			
0.500	+/-0.010	0.501	—			
0.125	+/-0.010	0.125	—			
0.188	+/-0.010	0.195	—			
0.562	+/-0.010	0.563	—			
0.125	+/-0.010	0.125	—			

Measured by: <i>QML</i>	Audited by: <i>QF</i>	Prototype Approval:	N/A
Date: 07/11/26	Date: 07/12/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.12.07	13.558 dimension removed	KJ/JLM	